

Work Order ID 63073

Wednesday, October 20, 2010 10:07:31 AM

Page 1

Item ID: D3049-1

Accept

Revision ID:

Item Name: Bearpaw

Start Date: 10/20/2010 Start Qty: 8.00

Required Date: 10/27/2010 Req'd Qty: 8.00

Reference:

Approvals:

Process Plan:

Date: 10-10-20

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3049

Rev A1

110

0.00

Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT BLANK AS PER FILE D3049-1_BLANK

10-10-20

8

120

0.00

HAAS 1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio FA165 and Dwg D3049 Identify as D3049-1
3-Deburr

JL/B.A 10/11/12

8

0

130

0.00

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

JL/B.A 10/11/12

8

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




Work Order ID 63073

Wednesday, October 20, 2010 10:07:31 AM

Page 2

Item ID:	D3049-1	Accept		Setup	Start	
Revision ID:						
Item Name:	Bearpaw				Stop	
Start Date:	10/20/2010	Start Qty: 8.00		Cust Item ID:		
Required Date:	10/27/2010	Req'd Qty: 8.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				5	0		
170  Packaging Packaging	Identify as per dwg & Stock Location: _____ Packaging Memo	0.00 0.00							
180  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

10/11/14

10/11/15

10/11/15

10/11/15

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Picklist Print

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Page 1

Work Order ID: 63073



Parent Item: D3049-1



Parent Item Name: Bearpaw


Start Date: 10/20/2010

Required Date: 10/27/2010

Start Qty: 8.00

Required Qty: 8.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10  UHMW 1" Black		Purchased	No			120	sf	104.0533	3.4	27.2			

10-10-25

(8)

Location

Loc Qty

Loc Code

MAT

104.0533

113903

79.7473

114624

8.8

115325

15.506

115955

45955

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DART AEROSPACE LTD		Work Order:	63073
Description: Bearpaw		Part Number:	D3049-1
Inspection Dwg: D3049 Rev: A1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	Ø0.260	+0.005/-0.000	260	✓		Vern	GA-01
B	0.93	+/-0.030	923	✓		"	"
C	0.40	+0.030/-0.000	410	✓		"	"
D	2.00	+/-0.030	2.000	✓		"	"
E	10.250	+/-0.010	10.250	✓		Vern	CNC-02
F	4.540	+/-0.030	4.540	✓		Vern	GA-01
G	5.88	+/-0.030	5.882	✓		"	"
H	0.38	+/-0.030	0.382	✓		"	"
I	11.50	+/-0.030	11.500	✓		Vern	CNC-02
J	0.07 x 45°	+0.030/-0.010	0.080x45°	✓		Vern	GA-01
K	0.44 - 0.47	+/-0.000	0.450	✓		"	"
L	R0.25	+/-0.030	R0.250	✓		R-G	ref.
M	0.38	+/-0.010	0.378	✓		Vern	GA-01
N	0.95	+0.030/-0.010	0.953	✓		"	"
O	0.69	+/-0.030	0.691	✓		"	"
P	0.20	+/-0.030	0.198	✓		D-G	GA-08
Q	23.00	+/-0.030	23.00	✓		Tape	GA-12
R	0.25 x 45°	+/-0.030	260x45°	✓		Vern	GA-01

Measured by:	SL/A.A
Date:	10/11/11 / 10/11/12

Audited by:	SA
Date:	10/11/15

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D135-692-011	KJ/RF	
B	08.05.06	Dimension I revised	KJ/DD	

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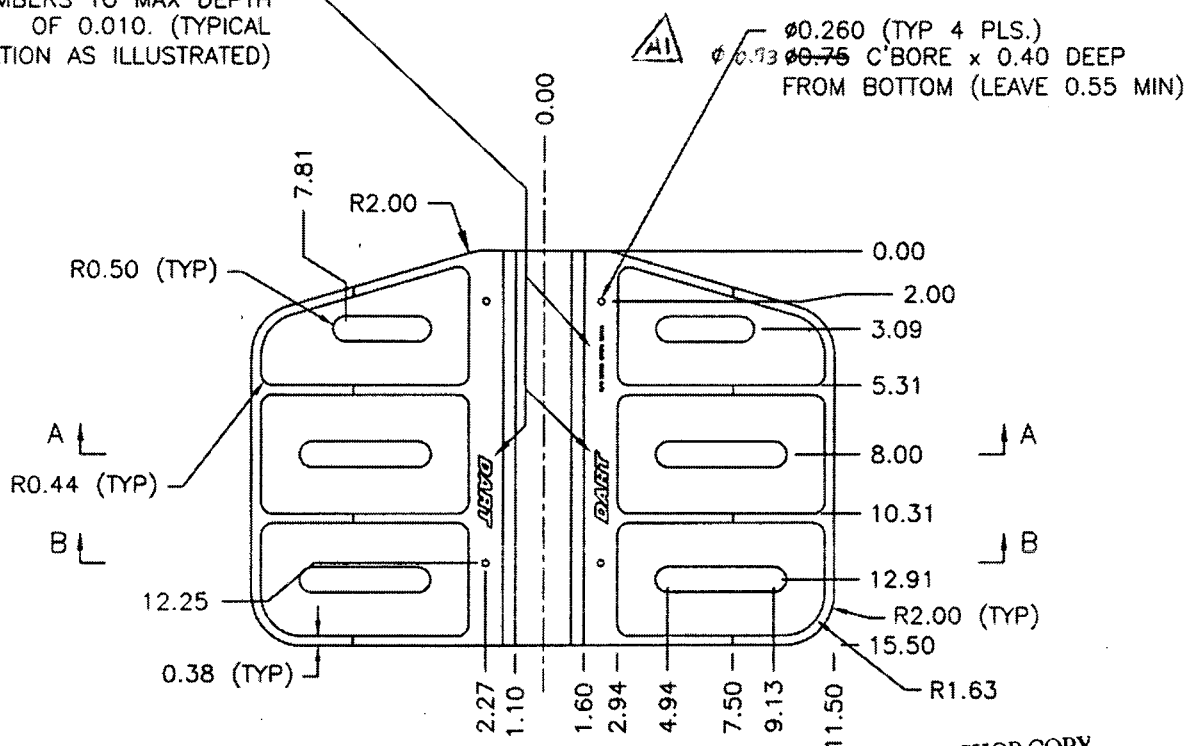
NOTE: Date & initial all entries



DESIGN RF		DRAWN BY RF		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]		APPROVED [Signature]		DRAWING NO. D3049	
DATE 01.10.18		TITLE BEARPAW		REV. A SHEET 1 OF 2	
A	01.10.18	NEW ISSUE			
AI	[Signature] 03.01.13	φ 0.93 WAS φ 0.75			

RELEASED
01.10.24

ENGRAVE DART LOGO TO
MAX DEPTH OF 0.012.
ENGRAVE PART AND BATCH
NUMBERS TO MAX DEPTH
OF 0.010. (TYPICAL
LOCATION AS ILLUSTRATED)



D3049-1 BEARPAW

NOTES:

- NOTES:
1) BEARPAW IS SYMMETRIC ABOUT CENTER LINE
2) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689,
1.00" THICK (MACHINE TO 0.950)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER 8173

NO. 63013

PL 10-10-20

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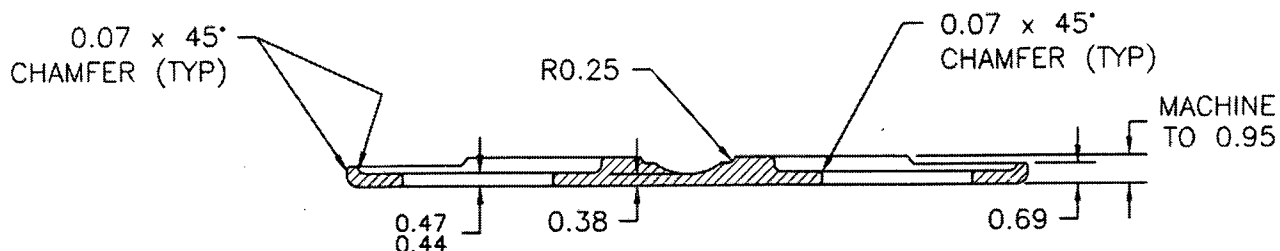
NOTE: Date & initial all entries



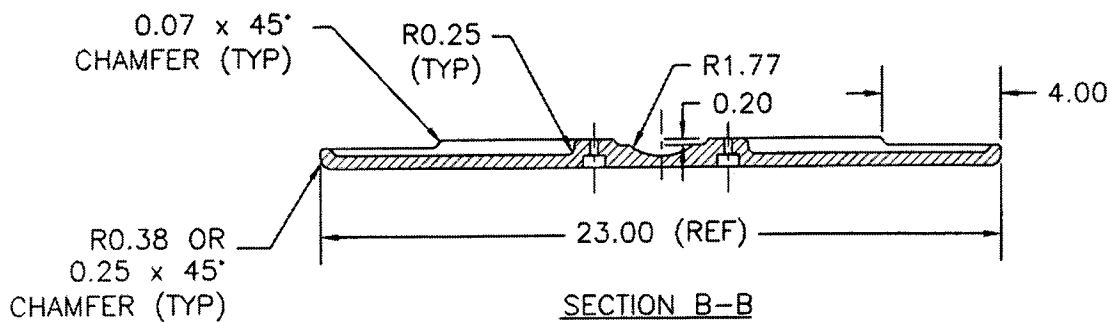
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3049	REV. A SHEET 2 OF 2
DATE 01.10.18		TITLE BEARPAW	SCALE 1:6

RELEASED
01.10.24 H

W/O 43073



SECTION A-A



SECTION B-B

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